

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021929**Date Inspected:** 15-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019*

Weld No: 166

Welder: 055491

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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PCMK: SEG-3019BB
Weld No: 171
Welder: 215553
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019BB
Weld No: 105
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019AB
Weld No: 136
WR: 20369
Welder: 044779
WPS-345-SMAW-4G(4F)-FCM-Repair-1

PCMK: SEG-3019X
Weld No: 008 and 009
WR: 20361
Welder: 054013
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Bay 14 (NDT)
Deck Panel; QAUT per ZPMC NDT Inspection Notification doc. #08553 Item 1. Welds identified as:
DP3172-001-017~021 and DP3173-001-020~024

Bay 16
This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Yang Yi Heng.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: W5-SB30-002
Weld No: 114, 046, and 047
Welder: 053753
WPS-B-P-2113

PCMK: E2-SB23-002
Weld No: 079
Welder: 053753
WPS-B-P-2113

PCMK: E5-SB29-001

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Weld No: 017, 018, 048, and 049

Welder: 201861

WPS-B-P-2113

PCMK: W2-SB20A-001

Weld No: 048, 049, 079 and 080

Welder: 201905

WPS-B-P-2113

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Yang Yi Heng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: E5-SB25C-005

Weld No: 126~131

Welder: 048625

WPS-2132-ESAB

PCMK: E2-SB26A-001

Weld No: 126~131

Welder: 222396

WPS-2132-ESAB

PCMK: W5-SB37-001

Weld No: 020

Welder: 222396

WPS-2132-ESAB

PCMK: W5-SB36-001

Weld No: 126~131

Welder: 053742

WPS-2132-ESAB

PCMK: W5-SB30-001

Weld No: 126~131

Welder: 222396

WPS-2132-ESAB

PCMK: W5-SB41C-001

Weld No: 122

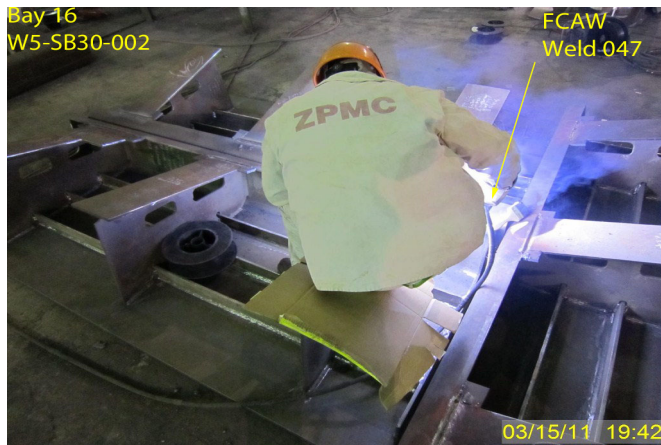
Welder: 201074

WPS-B-T-2132-ESAB

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
